

Date: Tuesday, 22/05/2007 10:11:35 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE 412
Job Number	: 32444		
Estimate Number	: 12783		
P.O. Number	: <i>N/A</i>	Part Number	: D412664145
This Issue	: 22/05/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D412-664-145 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 32443	Material	: <i>N/A</i>
Written By	: <i>LL</i>	Due Date	: 01/06/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>LL</i>		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPPD412-664-105 CHG 001

*SP 07/05/25*

2.0	D6019128	Crosstube Material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6019-128 Crosstube *B29365*

Check OD = 2.7500"; ID =

*SP 07/05/25*

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: 1-TURN AS PER FOLIO FA689 & DWG D412-664-145,

FOLIO REV: *21*DWG REV: *6*

2-DEBURR AS REQUIRED

*SP 07/05/25*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SP 07/05/25*

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*SP 07/05/28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/05/2007 10:11:36 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 32444

Part Number: D412664145

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JB 7-5-28

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-28

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-5-29

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-5-31

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-31

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-145 using CNC bender program

EL 7-5-71

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

27-06-04 (V)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-245

2-Ream hole to finish size in tube as per Dwg D412-664-245

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245

EL 7-6-22

JB 7-6-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: X-TUBE 412

Job Number: 32444

Part Number: D412664145

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube as per QSI 005 4.1

JB 7-6-25

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JA-06-26 ①

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JA-06-26 ①

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 4043 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C207/06/26 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

LC 7/6/25 ①

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

EN 07/07/03 ①

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

} 07-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 32444

Part Number: D412664145

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ET 07/08/17

22.0

D31893

Chafing Shield



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Chafing Shield

Batch:

31656

ET 07-06-17

23.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0798 sf(s)/Unit Total : 0.0798 sf(s)

Rubber Cushion

Cut to .630" X 4.5" X 4 PCS

Batch:

33833

ET 07-08-17

24.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1

Support

33560

ET 07-08-16

25.0

D2856600

Abrasion Strip



Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s)

Abrasion Strip

1X D2856 .250" X 8.42"

Batch:

26650

ET 07 08 17

26.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch:

103955

ET 07-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE 412

Job Number: 32444

Part Number: D412664145

Job Number:



905

Seq. #:

Machine Or Operation:

Description:

27.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 103897

RT 07 08 16

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-145

Install Chaffing Sheild

Instal supports with magnobond 6398 per dwg D412-664-245,  
cure for 12hrs before packaging.

Time & date of application:

4:00 07-08-16

Batch: 104723

RT  
07-08-16

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Gr 07/08/17

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-105

\*\*\*\*\*Ensure tube is not packaged if curing time is less than 12 hrs, see step 26 for application time & date  
\*\*\*\*\*

Time & date of packaging:

Location:

PPP Rev:

32187

Gr 07/08/17

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.17

Job Completion



U 07.08.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

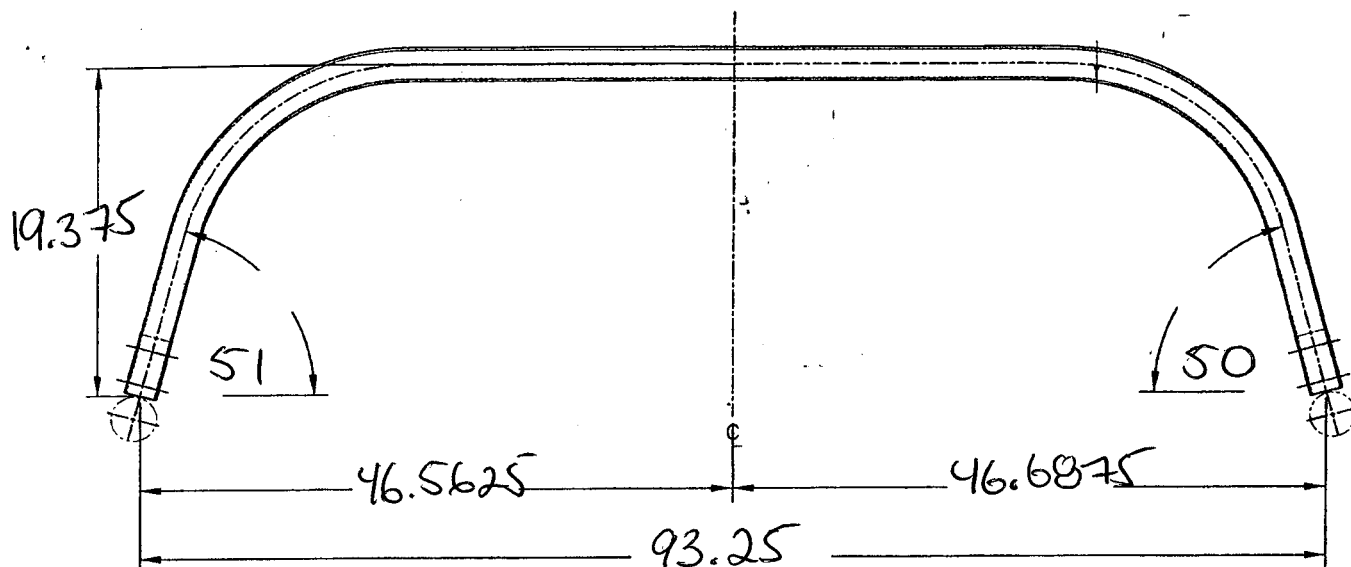
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	32444
<b>Description:</b> Crosstube Low Narrow Fwd (412)	<b>Part Number:</b>	D412-664-105
<b>Inspection Dwg:</b> D412-664-145 <b>Rev:</b> C		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	19.23	19.49
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46



Comments

QC15 Inspection	2006-04
Date	

Rev	Date	Change	Revised by	Approved
A	07.04.27	New Issue	KJ/JM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D412-664-145	REV. C SHEET 1 OF 3
DATE 07.03.29		TITLE CROSSTUBE ASS'Y (412 LOW-N FWD) NTS	
A	06.12.21	NEW ISSUE	
B	07.03.01	CHG RUBBER CUSHION	
C	07.03.29	CHG CLAMP & RUBBER CUSHION LGTH.	

**RELEASED**07.04.24 *[Signature]***PARTS LIST:**

Qty	Part Number	Description
X	D412-664-145	CROSSTUBE ASSEMBLY (412 LOW-NARROW FWD)
1	D6019-128	CROSSTUBE
1	D2856-250-842	ABRASION STRIP
2	D2893-1	SUPPORT
1	D3189-3	CHAFING SHIELD
4	D3595-063-450	RUBBER CUSHION
2	MS21920-24	CLAMP
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 32444
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 2) MATERIAL: MANUFACTURED FROM D6019-128  
FINISHED LENGTH = 124.48±0.020 (BEFORE BENDING/TRIMMING)
  - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
  - 4) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR D3189-3 CHAFING SHIELD AND ASSOCIATED HARDWARE.
  - 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
  - 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
  - 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
  - 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
  - 9) INSTALL D2856-XXX-YYY ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
  - 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
  - 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
  - 12) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
  - 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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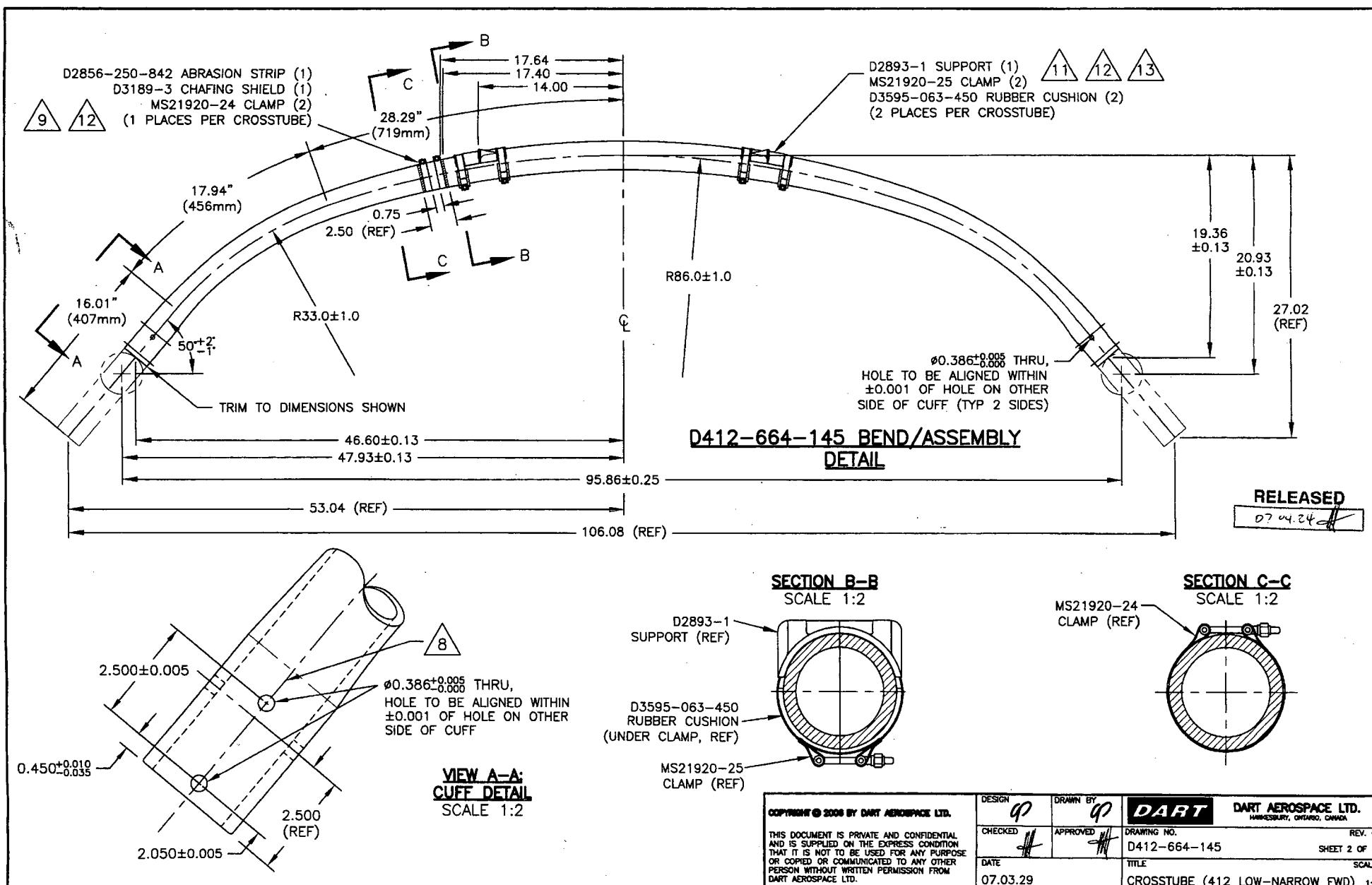
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D412-664-145	REV. C SHEET 2 OF 3
DATE 07.03.29		TITLE CROSSTUBE (412 LOW-NARROW FWD)		SCALE 1:8	

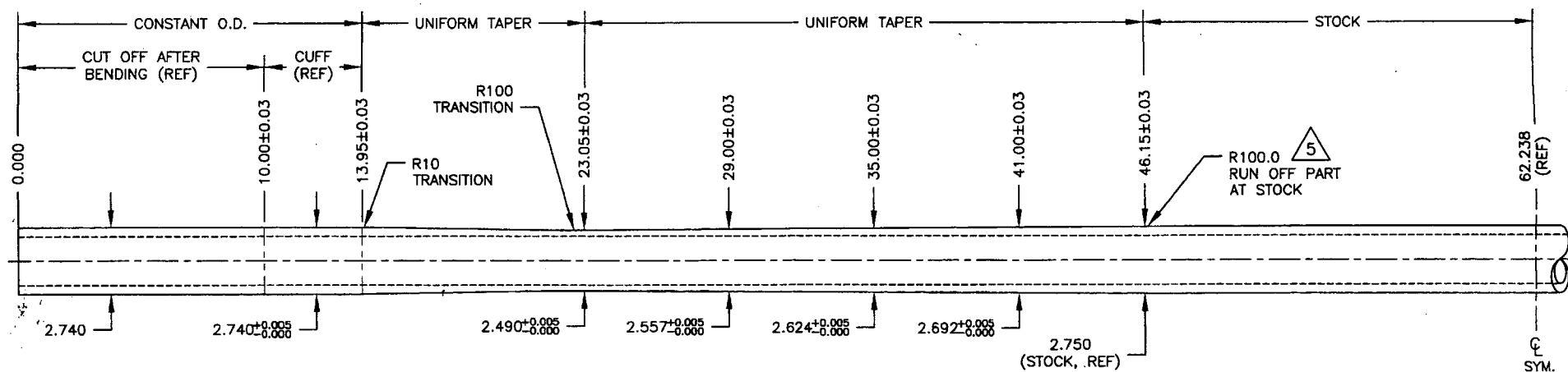
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# **D412-664-145 MACHINING DETAIL**

RELEASED

07.04.98

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DESIGN

q

DRAWN BY

q

**DART**

**DART AEROSPACE LTD.**  
HARRISBURG, ONTARIO, CANADA

CHECKED

#

APPROVED

#

DRAWING NO.  
D412-664-145

REV. C

DATE

07.03.29

TITLE

CROSSTUBE (412 LOW-NARROW FWD)

SCALE

1:4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DART AEROSPACE LTD		Work Order:
Description: Crosstube Assembly		Part Number: <i>D412664145</i>
Inspection Dwg: <i>D412664145</i>	Rev: <i>C</i>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.740	<i>±.005</i>	<i>2.745</i>	<i>/</i>		
	2.740	<i>±.000</i>	<i>2.745</i>	<i>/</i>		
	2.490	<i>"</i>	<i>2.494</i>	<i>/</i>		
	2.557	<i>"</i>	<i>2.561</i>	<i>/</i>		
	2.624	<i>"</i>	<i>2.628</i>	<i>/</i>		
	2.692	<i>"</i>	<i>2.694</i>	<i>/</i>		
	2.750	<i>"</i>	<i>2.751</i>	<i>/</i>		
SIDE B	2.740	<i>"</i>	<i>2.745</i>	<i>/</i>		
	2.740	<i>"</i>	<i>2.745</i>	<i>/</i>		
	2.490	<i>"</i>	<i>2.494</i>	<i>/</i>		
	2.557	<i>"</i>	<i>2.561</i>	<i>/</i>		
	2.624	<i>"</i>	<i>2.628</i>	<i>/</i>		
	2.692	<i>"</i>	<i>2.694</i>	<i>/</i>		
	2.750	<i>"</i>	<i>2.751</i>	<i>/</i>		
	124.476	<i>±.030</i>	<i>124.476</i>	<i>-</i>		

Measured by: <i>S.S.</i>	Audited by: <i>gml</i>	Prototype Approval:	N/A
Date: <i>07/05/24</i>	Date: <i>07/05/28</i>	Date:	N/A
Rev	Date	Change	Revised by
A		New Issue	KJ/JLM
			Approved



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36761

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D412-664-146 S/N's B32444 & B32443  
Qty. (2) P/N D206-667-203 S/N's B32143 & B32144  
Qty. (1) P/N D206-667-103BL S/N B32666  
Qty. (1) P/N D206-667-101 S/N B26378

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

Five (5) cross tubes PASSED inspection and one (1) FAILED inspection, P/N D206-667-203, S/N B32144.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLETCHER

DATE June 26, 2007

INSPECTION  
STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

4043

ADDRESS:

CONTACT NAME:

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT